

Date: Monday, 23/02/2009 10:14:02 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : AFT TUBE ASSEMBLY
<b>Job Number</b> : 45964	
<b>Estimate Number</b> : 10699	
<b>P.O. Number</b> :	<b>Part Number</b> : D3391025
<b>This Issue</b> : 23/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3391 REV H
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : H
<b>Previous Run</b> : 41762	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/03/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.02.23</u>	
<b>Comment</b> : Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manuf. Instructions JLM  est rev D 07.03.20 revF dwg EC est rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD Est Rev:F 07-11-13 ECN 1056 DD verified by: EC Est Rev:G 08-09-10 revH as per dwg DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



**Comment:** Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion B 32309

Identify as D3391-3

09.02.250

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------

**Comment:** MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: H & Dwg D3391 Rev: HA

09.02.250

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

09.02.250

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS1-Machine as per Folio FA 599 Rev: H & Dwg D3391 Rev: H

2-Deburr

B.A 09/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/02/2009 10:14:02 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45964

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 09/03/01

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 09/03/03

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

M 9-3-3

8.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

M 9-3-3

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/03 (X)

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

Tools: rill

9-3-4

MB  
09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/02/2009 10:14:02 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45964

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/04 (41)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AWM 9-3-4

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 02/03/05

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER

batch:

B 411863

(41)

M 9-3-5

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398

Batch: M 109 900

exp. date: 9-8-18

cure time 12hrs as per QSI0015

M 9-3-5

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/06 (41)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 110939

Pressure wash

UMP/FL

09/03/12

START TIME:

7:30

OVEN TEMPERATURE:

320°

FINISH TIME:

8:15

UMP/FL

09/03/17

(41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/02/2009 10:14:02 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45964

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-17

21

19.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

B43801

21

20.0

D35371

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

B415352

21

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

B333869

21

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B333868

21

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B333870

21

24.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PHENOLIC WASHER

B339275

21

25.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

batch: 11 108606

X

21

09-03-17

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 23/02/2009 10:14:02 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45964

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description:

or equivalent per  
QSI 017

*HL*

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
INSERT  
or equivalent  
Per QSI 017

*M119393 HL*

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Bolt  
Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	<i>M110985 HL</i>

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt

*M110916 HL*

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Inventory  
Pick:

Qty	Part Number	Description	Batch
<i>X</i> 2	AN960C10L	Washer	<i>M110915 HL</i>

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

✓ A/R Sikaflex-241/-291 *M109883*  
Sikaflex expiry date: *09/11*

*HL 09-03-17 (X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/02/2009 10:14:02 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45964

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/24

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PP 45974

09/03/25

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25

Job Completion



09/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 45958
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> G	<b>Page 1 of 1</b>

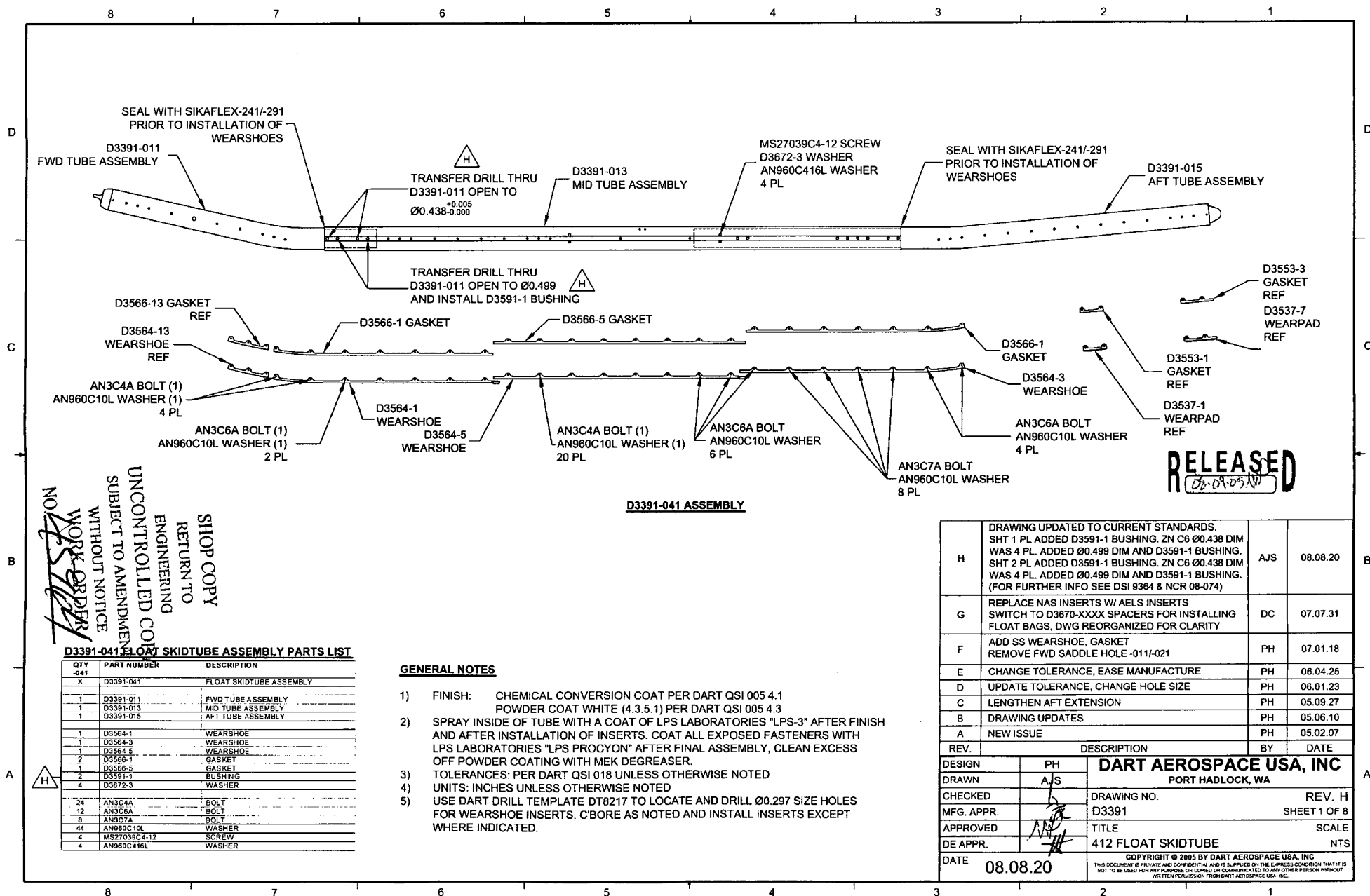
### FIRST ARTICLE INSPECTION CHECKLIST

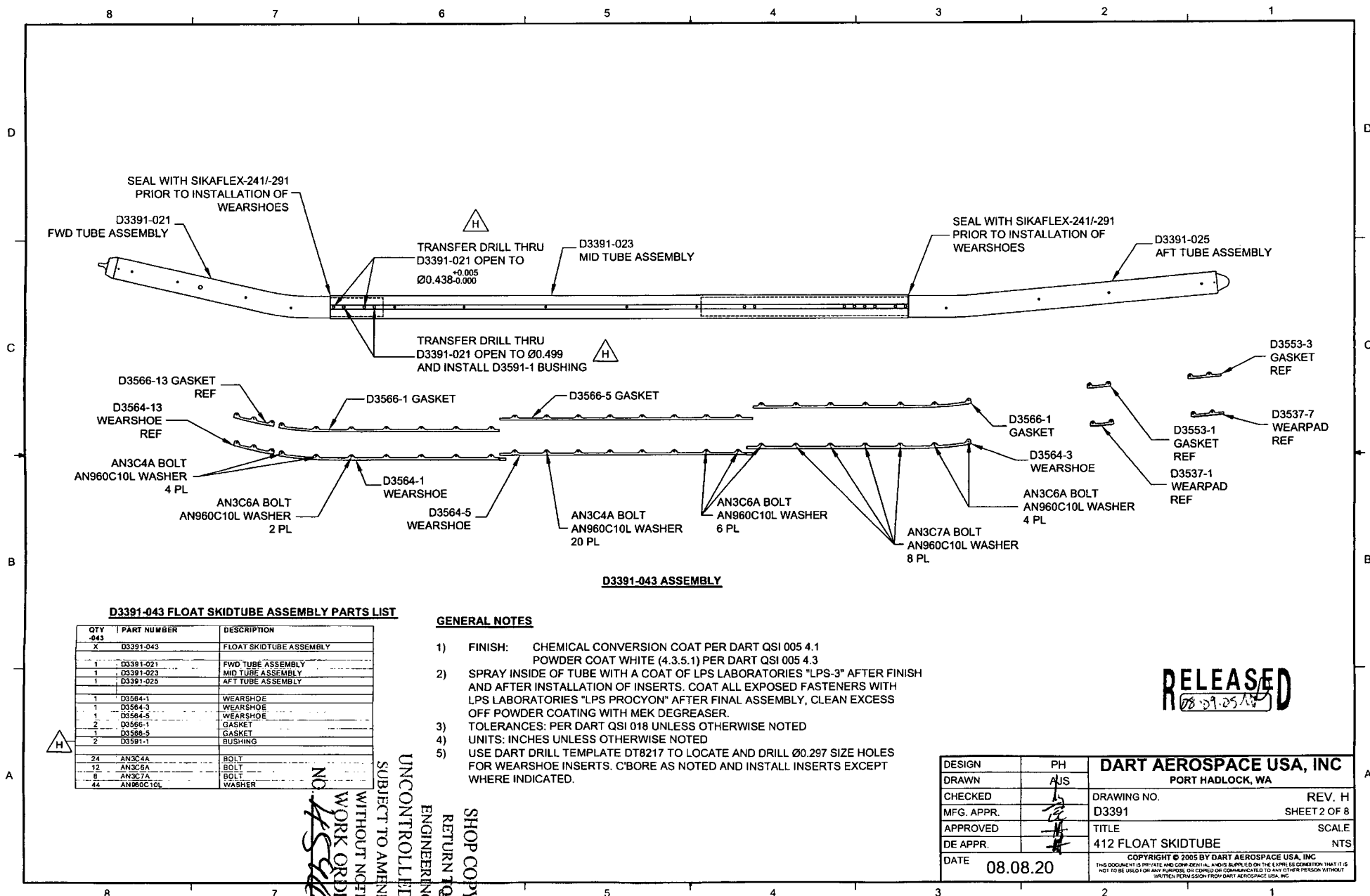
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.497	✓			
88.93	+/-0.030	88.930				
44.995	+/-0.030	44.995	✓			
3.200	+/-0.010	3.202	✓			
1.526	+0.000/-0.030	1.510	✓			
0.200	+/-0.010	0.200	✓			
7.500	+/-0.010	7.498	✓			
27.750	+/-0.010	21.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.297	✓			
0.200	+/-0.010	0.200	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	0.691	✓			
R0.062	+/-0.010	R0.063	✓			
Ø0.484	+0.005/-0.001	Ø0.487	✓			

<b>Measured by:</b> a.m. 8.A.09/03/01	<b>Audited by:</b> SP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09.02.25	<b>Date:</b> 09/03/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	





**D3391-043 ASSEMBLY**

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER

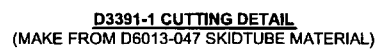
**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

**RELEASED**  
08-09-25/18

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

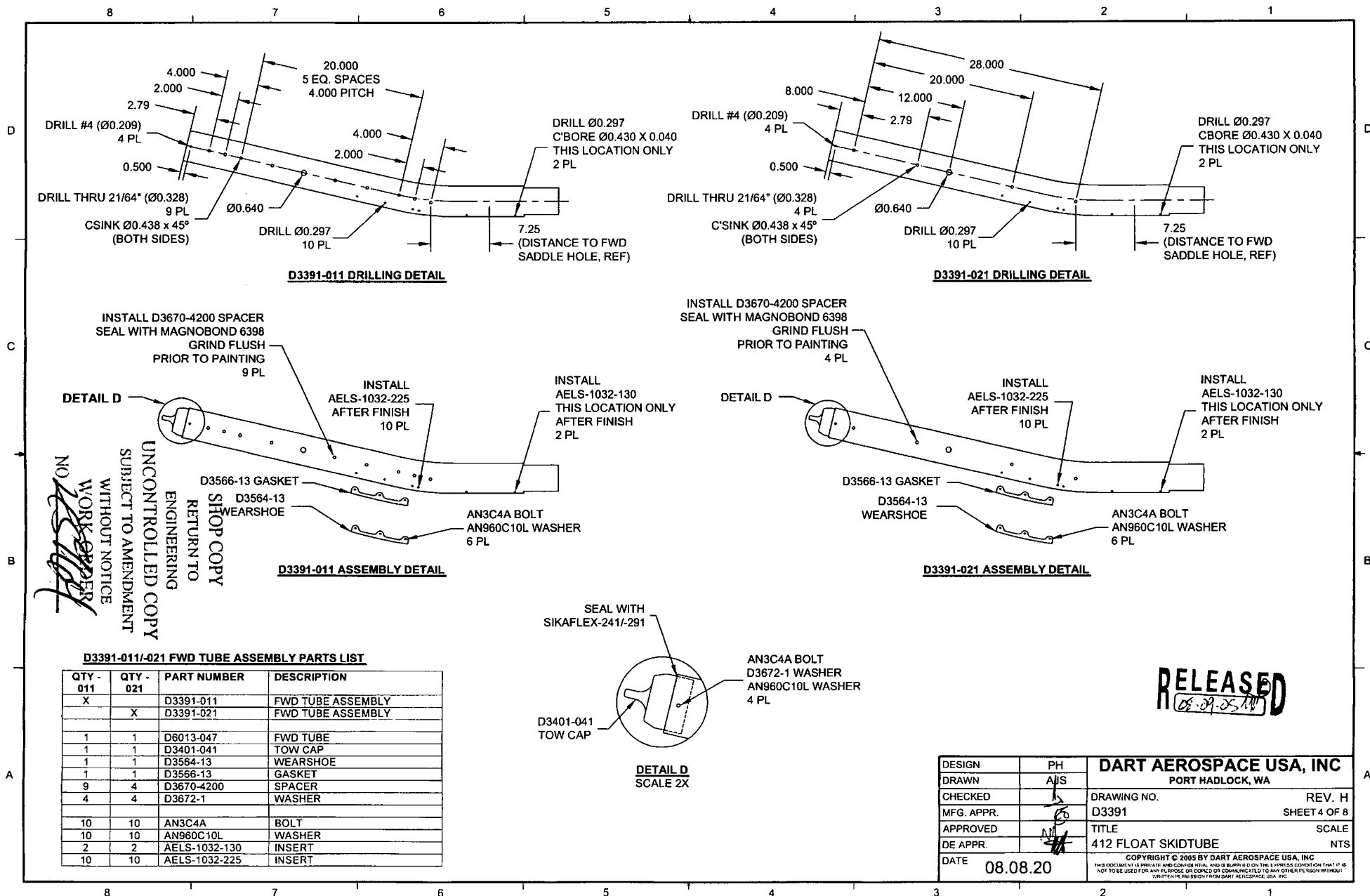
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 453404  
SHOP COPY  
RETURN TO  
ENGINEERING

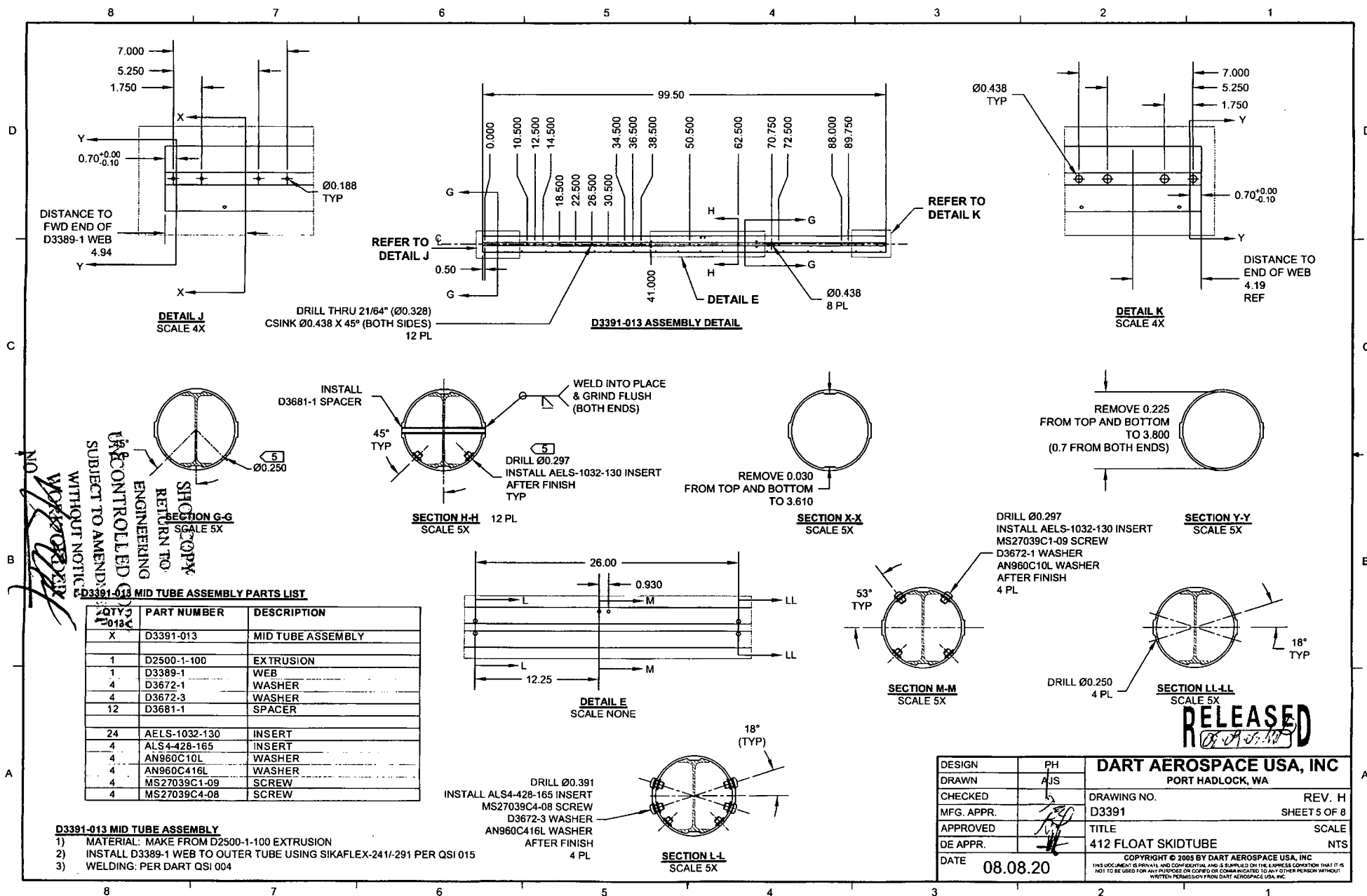


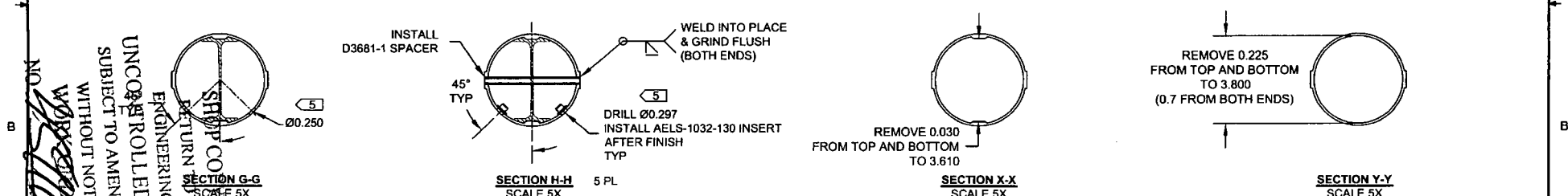
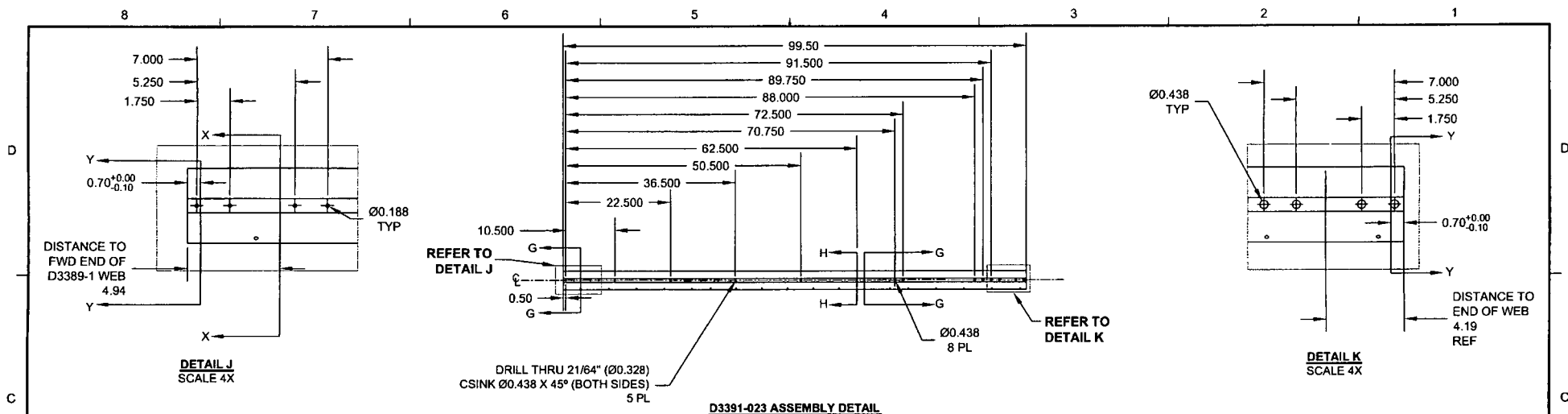
RELEASE  
J. J. O. S. N. W.

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCAL
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NT
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT          MAY NOT BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE          WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	









NO. 1000  
 WORK ORDER  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 UNCONTROLLED COPY  
 RETURN TO  
 SHOP CO.  
 ENGINEERING

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

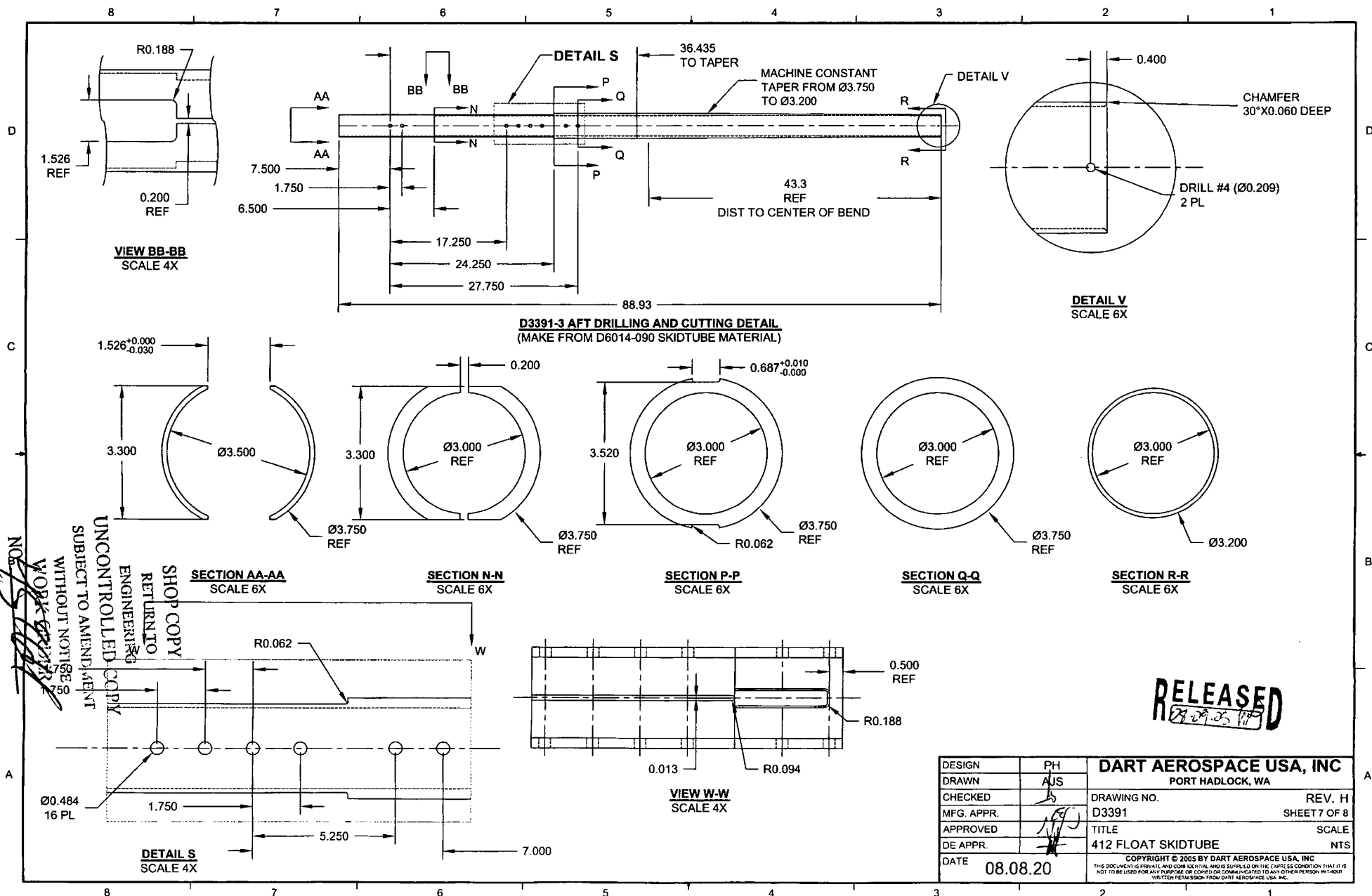
QTY	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

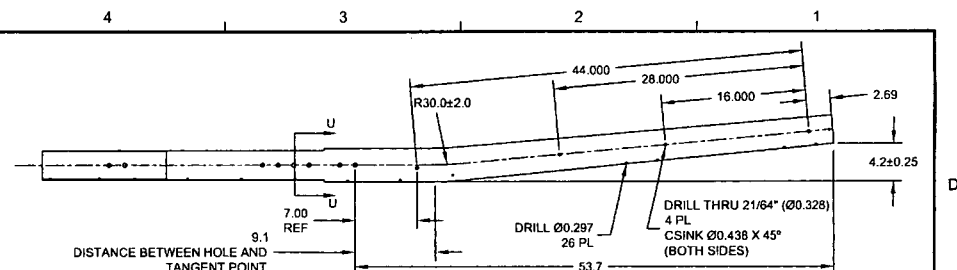
**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

**RELEASED**  
 08-05-17

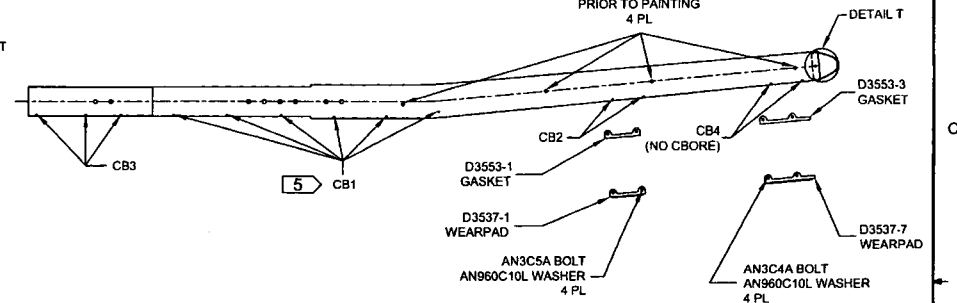
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





**D3391-025 BENDING AND DRILLING DETAIL**  
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER  
SEAL WITH MAGNOBOND 6398  
GRIND FLUSH  
PRIOR TO PAINTING



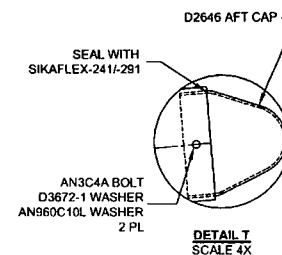
**D3391-025 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)

**D3391-025 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

Diagram 5 shows a cross-section of a ring with two internal pins, labeled 5.

DRILL Ø0.391  
CBORE Ø0.516 X 0.040 DEEP  
INSTALL ALS4-428-165 INSERT  
4 PL



**DETAIL T**  
**SCALE 4X**

RELEASE  
08-09-05 121

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
No. *2517*

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	<b>PORT HADLOCK, WA</b>	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
DATE 08.08.20		COPYRIGHT © 2003 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS UNCLASSIFIED AND THE INFORMATION CONTAINED HEREIN IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	